

# Work Order ID 66028

Wednesday, February 02, 2011 9:20:36 AM



Page 1

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: WLF

Date: 11-02-02

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3909	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg Trim rivet to 1.185" long								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EBH/02/10 (6)

EBH/02/10 (6)

(x6)

EBH/02/10

**Work Order ID 66028**

Wednesday, February 02, 2011 9:20:36 AM

Page 2

Item ID: D3909-041

Accept

Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/3/2011 Start Qty: 6.00

Required Date: 2/16/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 308

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Carlyle 611/02/14  
ME11-02-11

# Picklist Print

Wednesday, February 02, 2011 9:20:31 AM

Page 1

Work Order ID: 66028

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd



Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	5.0000	1	6			
<div> <div>Location</div> <div>ST020</div> <div>65617</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3909-1  Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	29.0000	2	12			
<div> <div>Location</div> <div>ST090</div> <div>65627</div> <div>ST095</div> <div>57824</div> <div>59155</div> </div> <div> <div>Loc Qty</div> <div>19</div> <div>19</div> <div>10</div> <div>8</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													
D3909-3  Fwd Lower Attach Arm		Manufactured	No			100	Each	1.0000	1	6			
<div> <div>Location</div> <div>ST095</div> <div>59442</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

ES 11/02/10  
B66029 (12)

ES 11/02/10  
B65627 (12)

ES 11/02/10  
B65628 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 02, 2011 9:20:31 AM

Page 2

Work Order ID: 66028

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

D3909-5  
  
 Eyebolt Stud

Manufactured No

100

Each

19.0000

1



6

*EP 5/11/02/10*

Location

Loc Qty

Loc Code

ST091

18

65629

18


ST095

1

58240

1

*6*

D3910-1  
  
 Crosstube Lug

Manufactured No

100

Each

1.0000

2



12

*EP 5/11/02/10*

Location

Loc Qty

Loc Code


st507

1

59708

1

*B65631 (120)*

*JS* D3917-1  
  
 Washer

Manufactured No

100

Each

48.0000

2



12

*EP 5/11/02/10*

Location

Loc Qty

Loc Code

ST065

40

57821

40

ST096

8

60170

8

*B66322 (4x)*

*8*

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 02, 2011 9:20:32 AM

Page 3

Work Order ID: 66028

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

AN3C12A Purchased No 100 Each 56.0000 4 24  
Bolts

Location	Loc Qty	Loc Code
ST351	56	
112314	8	
114761	11	
116022	2	
116289	17	
116428	18	

AN3C13 Purchased No 100 Each 58.0000 1 6  
Bolt

Location	Loc Qty	Loc Code
ST351	58	
114304	14	
114714	44	

MS17984-C413 Purchased No 100 Each 12.0000 1 6  
PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST315	12	
116706	12	

MS20615-4M20 Purchased No 100 Each 126.0000 3 18  
RIVET

Location	Loc Qty	Loc Code
ST323	126	
114808	26	
115054	100	

*EP 11/02/10*  
*M116786 (24x)*

*EP 11/02/10*  
*6*

*EP 11/02/10*  
*6*

*EP 11/02/10*  
*M115037 (18x)*

Wednesday, February 02, 2011 9:20:32 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, February 02, 2011 9:20:32 AM

Work Order ID: 66028



Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

AN310C3  
  
 Castellated Nut

Purchased No

100 Each 58.0000 1 6



*Ep 11/02/10*

Location	Loc Qty	Loc Code
ST349	58	
114304	8	
114714	50	

MS21043-3  
  
 Nut

Purchased No

100 Each 1,570.0000 4 24



*Ep 11/02/10*

Location	Loc Qty	Loc Code
FG	76	
103691	76	
ST301	1494	
112314	1494	

MS24665-151  
  
 Cotter Pin

Purchased No

100 Each 560.0000 1 6



*Ep 11/02/10*

Location	Loc Qty	Loc Code
ST309	560	
17566	560	

NAS1149C0332R  
  
 Washer

Purchased No

100 Each 4,296.0000 8 48



*Ep 11/02/10*

Location	Loc Qty	Loc Code
ST297	4296	
115000	125	
115698	35	
116025	1136	
116304	3000	

# Picklist Print

Wednesday, February 02, 2011 9:20:32 AM

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Parent Item: D3909-041



Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 2/3/2011

Required Date: 2/16/2011

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0363R

Purchased

No

100

Each

5,163.000

2

12



Washer



*Handwritten signature*  
*2/11/02/10*

Location

Loc Qty

Loc Code

ST297

5163

113524

33

113889

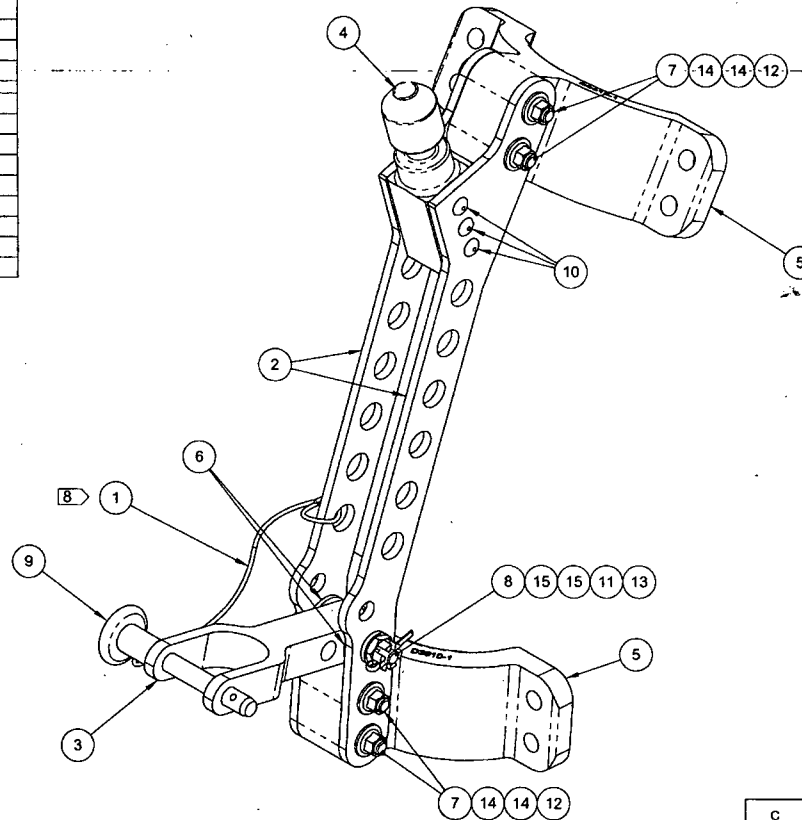
226

114742

4904

*Handwritten 12*

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



**D3909-041 FWD X-TUBE LUG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5), 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041-5).	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED, SECTION A-A & DIM 0.650 REMOVED, SIDE VIEW ADDED, DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05, WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		<b>FWD X-TUBE LUG ASSY</b>	
DATE	10.06.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

D3910-1  
X-TUBE LUG  
2 PL

D2690-6  
LANYARD

MS17984-C413  
PIP PIN

D3917-1  
WASHER

D3909-5  
EYEBOLT STUD

MS20615-4M20  
RIVET  
3 PL

D3909-1  
FWD X-TUBE LUG PLATE  
2 PL

D3909-3  
FWD LOWER ATTACH ARM

AN3C12A BOLT  
NAS1149C0332R WASHER, 2X  
MS21043-3 NUT  
4 PL

AN3C13 BOLT  
NAS1149C0363R WASHER, 2X  
AN310C3 NUT - CASTELLATED  
MS24665-151 COTTER PIN

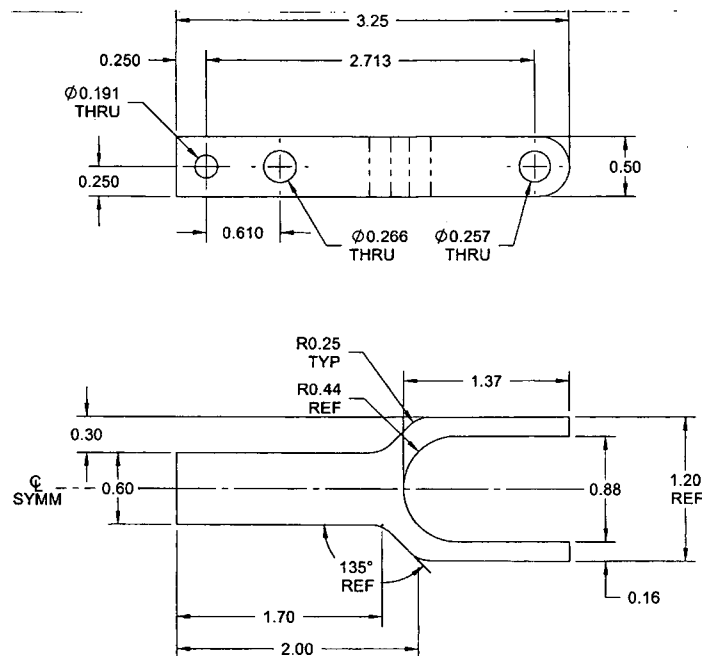
#66028

**RELEASED**  
2010-08-04

**D3909-041 FWD X-TUBE LUG ASSY**

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY.	NTS
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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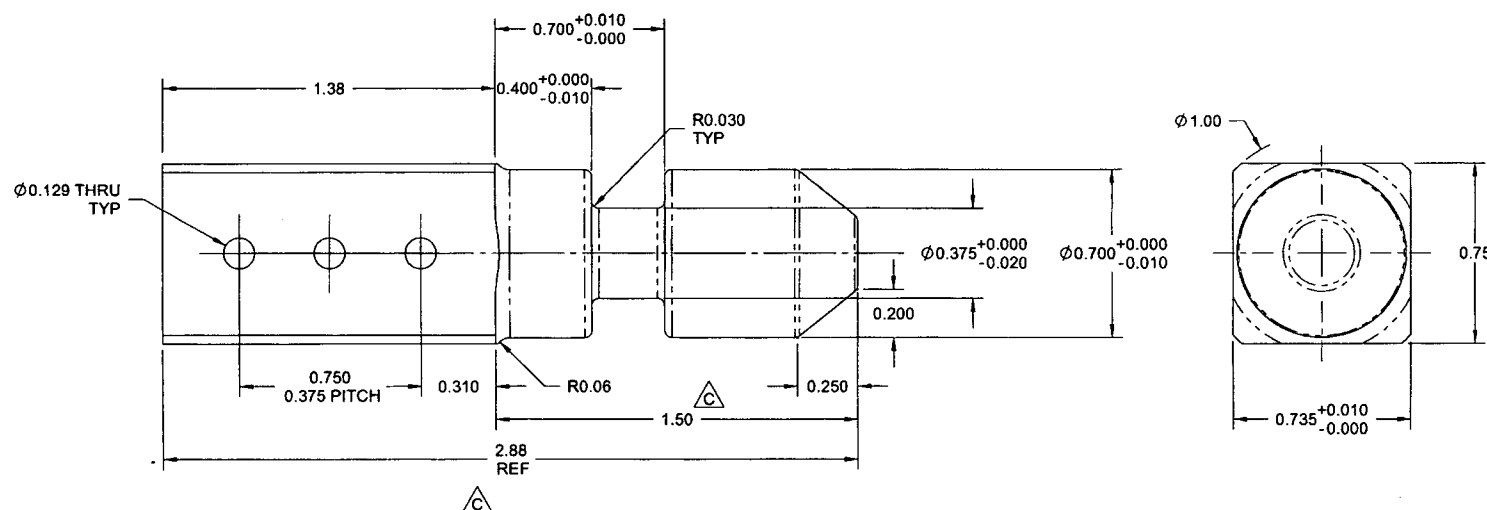


\$66028

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. 0
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR: --	<i>[Signature]</i>	<b>FWD X-TUBE LUG ASSY</b>	NTS
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RELEASE  
2010-08-01



#66028

RELEASE  
2010-08-04  
MD

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276  
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV.
MFG. APPR.		D3909	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NT
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